



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3200-1
Job Sheet 170427



Part No: D3200-1

Job Qty: 20 ea

Part Name: Door Post Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	1/30/18	1/30/18	0.00	0.00	Start Up Machining-2		mark 8/21/27
100	Bandsaw	20 pcs	1/30/18	1/30/18	0.00	0.18	Bandsaw1		"
110	CNC Vertical Machining	20 pcs	1/31/18	1/31/18	0.07	6.58	HAAS1-3		"
130	QC	20 pcs	1/31/18	1/31/18	0.00	0.00	QC8 Machining-2		18/1/130
140	Packaging	20 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-1	ST 022	JAN 31 2018
150	QC21-SA	20 Ea	1/31/18	1/31/18	0.00	0.00	QC21		

Part Op 100 - Cut blank: 2.700" x 2.700

Descriptions: 110 - 1-Machine D3200-1 as per Folio FA337 and Dwg D3200

JAN 31 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	1	713	0	0

Batch # FM136453

30X=652 p²

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid- Mach Thermoform Large		AGAINST DEPARTMENT/PROCESS Door Post Block S036514	
Date :		Step #:		QTY		PART NO: D3200-1 Original Serial #: S036514 Revision: Operation: Change No:	
Description Work Order Deviation						2) Approval _____ ted By _____ Supervisor ification _____ rdinator val _____ Wrong ensions tolerance ct issing	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/C ☐ Set-up ☐ BOM/Route ☐ Broken/Damage ☐ Inspection Incoi ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incc ☐ Drill Holes ☐	
OTHER : _____						Misaligned/off center Turning Sequence	

 Job No: 170427
 Start up Operation 01/29/18

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 CANADA
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 www.dartaerospace.com

Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Door Post Block	0.196inches + 0.005 - 0.000	0.201 0.196	
2	Door Post Block	0.405inches ± 0.010	0.415 0.395	
3	Door Post Block	100Degrees ± 0	100 100	
4	Door Post Block	0.100inches ± 0.010	0.110 0.090	
5	Door Post Block	0.130inches ± 0.010	0.140 0.120	
6	Door Post Block	1.630inches ± 0.005	1.635 1.625	
7	Door Post Block	0.440inches ± 0.030	0.470 0.410	
8	Door Post Block	2.500inches ± 0.010	2.510 2.490	
9	Door Post Block	1.845inches ± 0.010	1.855 1.835	
10	Door Post Block	1.000inches ± 0.010	1.010 0.990	
11	Door Post Block	1.620inches ± 0.050	1.670 1.570	
12	Door Post Block	2.500inches ± 0.030	2.530 2.470	
13	Door Post Block	0.750inches ± 0.030	0.780 0.720	

Plex 1/16/18 11:25 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					